

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020646**Date Inspected:** 13-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

Repair welding of weld joint no: SEG3013P-068 [K-Plate 3010A to Floor Beam (FB) 3176A, complete joint penetration (CJP) weld at Panel Point (PP) 118]. The welder is identified as 066361 and was observed welding in the 3G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 20230.

OBG Seg 14W:

The SMAW process on weld joint no: SEG3020U-588 [Anchor Plate (AP) 3032A to Bottom Plate (BP)

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3087A/3088A, CJP weld at PP126]. The welders are identified as 067904 and 067588 and were observed welding in the 2G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-Tc-U4b-FCM-1.

Repair welding of weld joint no: SEG3020BB-055 [BP3090A to Vertical Shear Plate SA3449A, CJP weld at PP125-126]. The welder is identified as 045246 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair-1. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2752 Rev-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SA3446-012 [Anchorage Brace Plate - X5056D to X5074D, Partial Joint Penetration (PJP) weld at PP126]. The welder is identified as 066421 and was observed welding in the 1G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-ESAB.

Repair welding of weld joint no: SEG3020BB-010 (BP3088A to Vertical Shear Plate SA3444A, CJP weld, at PP125-126). The welder is identified as 066038 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair-1. Repair welding was done as per CWR Report: B-CWR 2793 Rev-0.

The FCAW process on weld joint no: SEG3020BB-114 (AP3032A to Vertical Shear Plate SA3448A, CJP weld at PP126). The welder is identified as 066695 and was observed welding in the 3G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
